

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008073**Date Inspected:** 20-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

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This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 026 located on SEG-036B. Welder is identified as 068596. ZPMC QC identified as Zhang Qiang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

SAW process welding of weld joint # 005 located on DP195A+DP222A. Welder is identified as 045265. ZPMC QC identified as Sun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-12c-S-2.

SAW process welding of weld joint # 004 located on D387A+DP414A. Welder is identified as 045265. ZPMC QC identified as Sun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-12c-S-2.

SMAW process welding of weld joint # 069, 070, 073, 074 located on CSD2-PP57.5. Welder is identified as 037779. ZPMC QC identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with

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the WPS-B-P-2113.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang :150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gaikwad,Umesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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